



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-541-044
Job Sheet 190434



Part No: D205-541-044

Job Qty: 1 pcs

Part Name: Bell Medium Heli-Utility-Basket™ - RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/8/19

Job Tracking No:

Due Date: 3/22/19

Created By: Jesse White

Type: Stock *SIOP*

Description: SIOP

Note: DWG DSI9667 REV A, IIN D205-541 REV J SHEETS 29-31 IPP Rev:C Re-Format 02-08-30 KJ IPP Rev:D chg to revG Ecn 1157 08-03-19 DD verified by: IPP REV:E 13.06.21 IIN-D205-541 REV.J DD VERF:JFS IPP REV:F 15.02.02 AS PER DIS9667 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	1 pcs	3/22/19		0.00	1.18	Small Fab - 1		<i>BEB 19-04-05</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	1 pcs	3/22/19		0.00	0.00	QC 5 - 10		DAS APR 08 2019 68 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 1-1 - Pick Kit - B4B	1 pcs	3/22/19		0.00	0.00	Packaging 1 - 1 - B4B		APR 11 2019
							Packaging 1 - 2 - B4B		
							Packaging 1 - 3 - B4B		
							Packaging 1 - 4 - B4B		
							Packaging 1 - 5 - B4B		
							Packaging 1 - 6 - B4B		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
140 QC 4	1 pcs	3/22/19	0.00 0.00	QC 4 - 26	
				QC 4 - 28	
				QC 4 - 42	
				QC 4 - 58	
				QC 4 - 6	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
145 DC - 1 - B4B	1 pcs	3/22/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
150 Packaging 3-1 - Stock - B4B	1 pcs	3/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
160	QC 21 - FG	1 pcs	3/22/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

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9-89

Part Op 110 - (Small Fab) Assemble as per Dwg.

Descriptions: 120 - (QC5- Inspect part completeness to step on W/O)

130 - (Pick Kit)

140 - (QC4- 100% Inspect kits for completeness)

145 - (Document Control) Photocopy bluefile & type labels per PPPD205-541-044 CHG003

150 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D205-541-044 Location: _____

160 - (QC21- Final Inspection - Work Order Release)

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
Other/Details: _____					

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
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Other/Details:					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	AN3-16A	2	77	0
	AN4-22A	1	114	0
	AN4-24A	1	43	0
	AN4-7A	2	144	0
	AN5-17A	4	183	0
	AN970-4	4	91	0
	D2022-101	2	75	0
	D2258-300	1	5	0
	D2332-041	1	7	0
	D2512	1	1	0
	D2530	1	1	0
	D2535	2	47	0
	D2537	2	120	0
	D2931	2	807	0
	D3053-042	1	2	0
	MS20600-AD4W3	2	139	0
	MS21042L3	2	2,712	0
	MS21042L4	4	3,135	0
	MS21042L5	4	867	0
	NAS1149D0416J	2	2,154	0
	NAS1149D0463J	2	4,230	0
	NAS1149D0563J	4	973	0
	NAS1149DN832J	2	1,261	0
130-Packaging 1-1 - Pick Kit - B4B	AN4-12A	3	183	0
	AN4-13A	9	1,207	0
	AN4-14A	2	520	0
	AN4-7A	2	144	0
	AN5-13A	1	90	0
	AN5-7A	1	3,200	0
	D2199-1	1	4	0
	D2199-23	1	3	0
	D2199-25	1	3	0
	D2498	1	5	0
	D2499	1	6	0
	D2515	2	82	0
	D3052-1	1	3	0
	MS21042L4	16	3,135	0
	MS21042L5	2	867	0
	NAS1149D0432J	4	538	0
	NAS1149D0463J	33	4,230	0
	NAS1149D0532J	2	153	0
	NAS1149D0563J	5	973	0
Part Specifications				
Specifications could not be found.				

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

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Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Eng. (Non-AW) ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Water Jet ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Supplier Quality ☐</td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier Quality ☐															
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐																													
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Date : _____		QTY Affected : _____		MRB (QSI042) _____																												
				Completed By _____																												
				Lead hand / Supervisor _____																												
				QC / QA Coordinator _____																												
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Other/Details: _____																																

1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com



Container No: S169908

Part: D205-541-044

Job No: 190434

Serial No/Batch: S169908

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH96-120 Issue 2, EAA 67C SR0069f

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-k-g	132.25 in 3.36 m	15606 in-lb 180.1 m-k-g
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-k-g	132.25 in 3.36 m	15606 in-lb 180.1 m-k-g
D205-541-045 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	- 63.13 in - 1.60 m	- 6566 in-lb - 75.7 m-k-g	132.25 in 3.36 m	13754 in-lb 158.9 m-k-g
D205-541-046 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	+ 63.13 in + 1.60 m	+ 6566 in-lb + 75.7 m-k-g	132.25 in 3.36 m	13754 in-lb 158.9 m-k-g
D205-541-047 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	- 76.11 in - 1.93 m	- 1066 in-lb - 12.4 m-k-g	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-k-g
D205-541-048 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	+ 76.11 in + 1.93 m	+ 1066 in-lb + 12.4 m-k-g	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-k-g
D205-541-141 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	- 59.9 in - 1.5 m	- 4133 in-lb - 47.1 m-k-g	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-k-g
D205-541-142 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	+ 59.9 in + 1.5 m	+ 4133 in-lb + 47.1 m-k-g	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-k-g

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
X						D205-541-043	HELI-UTILITY-BASKET, LH
	X					D205-541-044	HELI-UTILITY-BASKET, RH
		X				D205-541-045	HELI-UTILITY-BASKET, LH
			X			D205-541-046	HELI UTILITY-BASKET, RH
				X		D205-541-141	HELI-UTILITY-BASKET, LH
					X	D205-541-142	HELI UTILITY-BASKET, RH
				1	1	DSI 9302-011	STRUT MODIFICATION KIT (FOR D205-633 STEP INSTALLATION)
2*	2*					D2022-101	SPACER
				2	2	D2022-101	SPACER (FOR D205-633 STEP INSTALLATION)
1	1	1	1			D2199-1	STRUT
1	1	1	1			D2199-23	STRUT
1	1	1	1			D2199-25	STRUT
1*	1*	1*	1*			D2258-300	LABEL
1*	1*	1*	1*			D2332-041	PROP ASSEMBLY
				1	1	D2332-041	PROP ASSEMBLY (OPTIONAL)
				1	1	D2464-0410	NEOPRENE SEAL
1	1	1	1			D2498	MOUNTING LUG
1	1	1	1			D2499	MOUNTING LUG
1*	1*					D2512	BASKET LID ASSEMBLY

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Revision: J

Date: 10.03.08

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
2	2	2	2			D2515	BUSHING
1*	1*	1*	1*			D2530	HANDLE ASSEMBLY
2*	2*	2*	2*			D2535	SPRING
2*	2*	2*	2*			D2537	BUSHING
2*	2*					D2931	BUMPER
1	1	1	1			D3052-1	MOUNTING LUG
1*						D3053-041	BASKET BASE ASSEMBLY, LH
	1*					D3053-042	BASKET BASE ASSEMBLY, RH
		1*				D3712-041	BASKET BASE
			1*			D3712-042	BASKET BASE
		1*				D3713-041	LID ASSEMBLY
			1*			D3713-042	LID ASSEMBLY
		6*	6*			D3723-1	BUSHING
				2	2	D3953-9	GAS SPRING SPACER (OPTIONAL)
				1		D4041-011	SHORT BASKET ASS'Y, LH
					1	D4041-012	SHORT BASKET ASS'Y, RH
				1		D4048-041	MOUNTING LUG ASS'Y
					1	D4048-042	MOUNTING LUG ASS'Y
				1		D4048-5	MOUNTING LUG
					1	D4048-6	MOUNTING LUG
				1		D4048-7	MOUNTING LUG
					1	D4048-8	MOUNTING LUG
				6	6	D4048-9	BUSHING
				1		D4049-041	MOUNTING LUG ASS'Y
					1	D4049-042	MOUNTING LUG ASS'Y
				1		D4049-5	MOUNTING LUG
					1	D4049-8	MOUNTING LUG
				1	1	D4050-1	STRUT
				1	1	D4050-3	STRUT
				1		D4050-5	STRUT
					1	D4050-8	STRUT
				1		D4051-041	GUARD (OPTIONAL)
					1	D4051-042	GUARD (OPTIONAL)
				2	2	D4052-1	EYE BOLT
				10	10	AN3-5A	BOLT
				1	1	AN3-7A	BOLT (OPTIONAL)
				4	4	AN3-11A	BOLT (OPTIONAL)
2*	2*	2*	2*			AN3-16A	BOLT
				5	5	AN4-6A	BOLT
2*	2*					AN4-7A	BOLT
2	2	2	2	1	1	AN4-7A	BOLT
3	3	3	3	2	2	AN4-12A	BOLT
9	9	9	9			AN4-13A	BOLT
2	2	2	2	11	11	AN4-14A	BOLT
				1	1	AN4-16A	BOLT
		3*	3*			AN4-20A	BOLT

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*			AN4-22A	BOLT
1*	1*	1*	1*			AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: J

Date: 10.03.08

Change Record

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Part Number: D205-541-043/-044

Description: HELI UTILITY BASKET, LH/RH

[illegible]